

Work Order ID 109814

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Item ID: D2596 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web, 205 Skidtube
 Start Date: 12/02/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/16/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-02 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								
100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5"								
	2- Use Jig DT8093 to drill pilot holes #30								
	3- Open to 0.630" diameter as per Dwg D2596								
	4- Deburr								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

4 4 13-12-03
 DGL.
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Item ID: D2596

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 12/02/13 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 12/16/13 Req'd Qty: 4.00 ***4***

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LL</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

BB 13/12/04

13/12/04

MS 13/12-04

Picklist Print

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Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 12/02/13

Required Date: 12/16/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	54.0000	1	4			

D2500-3-100

**

Ext'n - 'I' Beam Web 4"

Location

Loc Qty

Loc Code

HALL

54

84873

4

89110

50

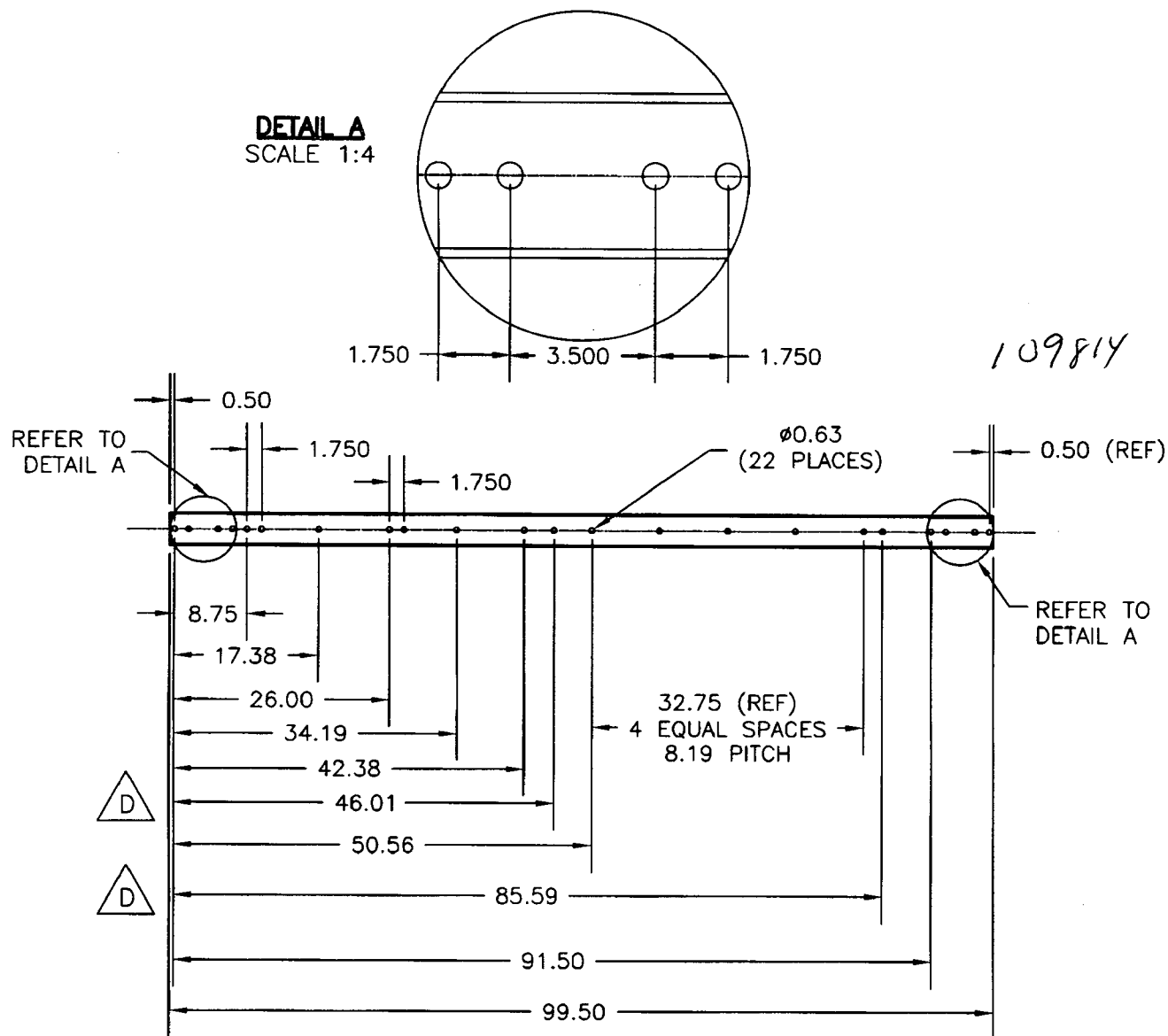
4

13-12-03. JGL



RELEASED
07 DEC 1987

DESIGN	RA	DRAWN BY	AT	DART AEROSPACE LTD
CHECKED	AT	APPROVED	AT	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.17	DRAWING NO.	D2596	REV. D
		TITLE	205 WEB	SHEET 1 OF 1
		SCALE	1:20	
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020